

split

# Work Order ID 58288 -1

May 3, 2010 10:25:47 AM

Page 1

Item ID: D2565-103

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Date: 10-5-03

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Draw Nbr

Revision Nbr

D2565

Rev E

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

100



Brake NC

Brake NC

NC BRAKE

0.00

Memo

Punch to length as per Dwg D2565 using DT8313

0.00

SB 10/05/13

①

110



Small Fab

Small Fab

Small Fab

0.00

Memo

1-Drill hole open to .316 O as per Dwg D2565 (one end only) 2-Deburr

0.00

SB 10/05/17

①

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 10/05/17

①

Accept



Setup Start

Stop

Cust Item ID:

Customer:





Work Order ID 58288

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Page 2

Item ID: D2565-103

Revision ID:

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Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Memo

START TIME:

1:15pm

FINISH TIME:

12:45pm

OVEN TEMPERATURE:

400°F

= 294 10/05/17

1 0

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 BR 10-5-17.

150



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

270

0.00

Proposed 1







Order ID 58288

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Page 3

Item ID: D2565-103

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/05/17  
10-5-17  
①





Print

3, 2010 10:25:46 AM

Work Order ID: 58288

Parent Item: D2565-103

Parent Item Name: Strut

Comments: IPP: F 02.04.16 Added dwg Rev.C1 NG

Component Item ID/  
Item Name

Replacement  
Item ID

Mfg/  
Purch

Purchased

M304TR0.750W.049



304 RD Tube .750 x .049W



Bin  
Item

Primary  
Location

Last  
Location

Route  
Seq ID

Unit of  
Measure

Qty on  
Hand

Qty per Kit

Qty  
Issued

Date  
Issued

Status

100

f

303.4562

1.5175



Location

Loc Qty

Loc Code

MAT

275.5927

108498

0

114482

275.5927

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Required Qty: 10.00

Page 1

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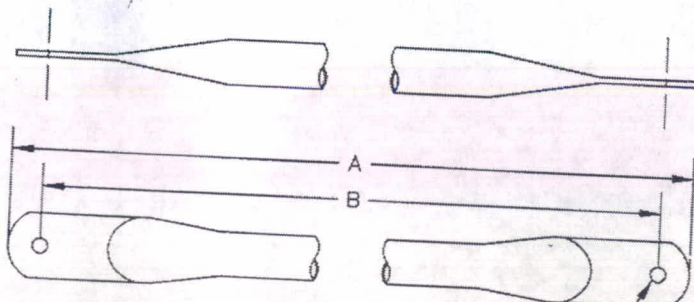
**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E
DATE 04.05.05		TITLE STRUT	SHEET 1 OF 1
A	96.05.03	NEW ISSUE	SCALE 1:3
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 58288  
3810-5-03



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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